

Date: Wednesday, 18/06/2008 1:33:04 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BASE
Job Number :	39938		
Estimate Number :	13036		
P.O. Number :		Part Number :	D365111
This Issue :	18/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3651 REV.B
First Issue :	/ /	Project Number :	N/A
Previous Run :	37139	Drawing Revision :	B
	Type :	Material :	
	SMALL / MED FAB	Due Date :	07/07/2008
Written By :		Qty:	2
Checked & Approved By :	JULIE LECOCQ	Um:	Each
Comment :	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	G89	coated cloth
-----	-----	--------------



3



Comment: Qty.: 0.7203 sf(s)/Unit Total : 1.4406 sf(s)

G-89 coated cloth

Batch: 105928 IB 8-6-20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3651

Dwg Rev: B

Prog Rev: B

IB 8-6-20

4

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-6-20

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

808/07/03 (49)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and stock

Location: GA

SB 08/07/21

9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:33:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 39938

Part Number: D365111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/21 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 29938
Description: Gasket		Part Number: D3651-11
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

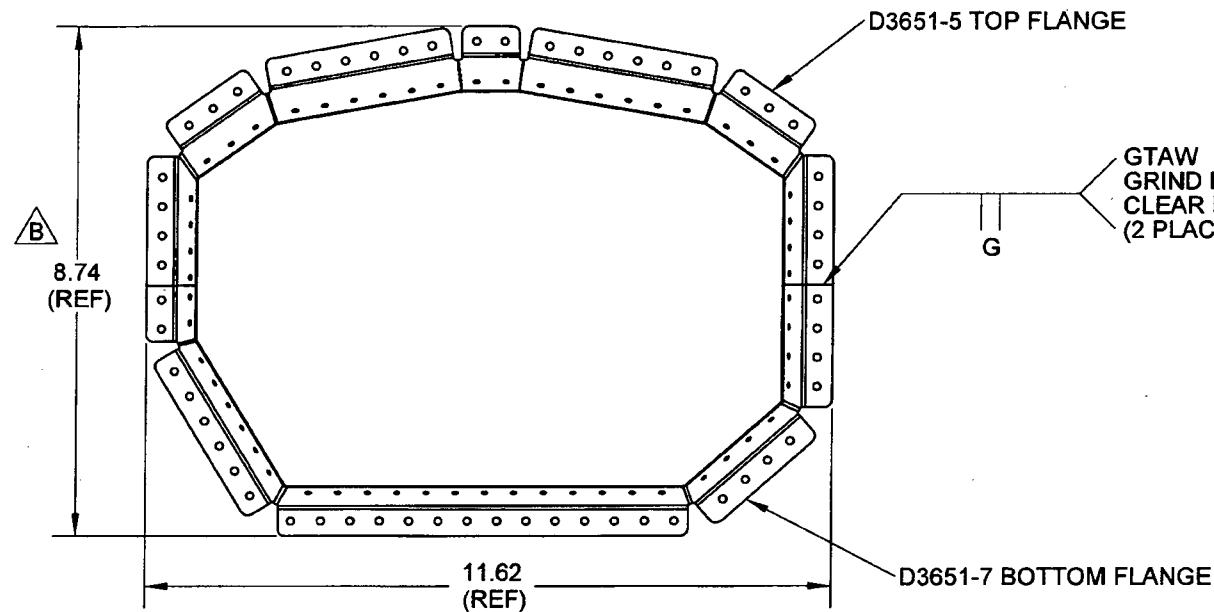
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	1.33	*			
Ø0.250	+0.005/-0.001	555	*			
8.74	+/-0.030	8.74	*			
11.62	+/-0.030	11.62	*			
1.62	+/-0.030	1.612	*			
1.41	+/-0.030	1.39	*			
0.500	+/-0.010	500	*			
0.600	+/-0.010	600	*			
0.634	+/-0.010	634	*			
2.564	+/-0.010	2.564	*			
2.081	+/-0.010	2.081	*			
3.731	+/-0.010	3.731	*			
2.100	+/-0.010	2.100	*			
9.706	+/-0.010	9.706	*			
7.969	+/-0.010	7.969	*			
6.96	+/-0.030	6.96	*			
5.698	+/-0.010	5.698	*			
3.698	+/-0.010	3.698	*			
2.564	+/-0.010	2.564	*			
2.020	+/-0.010	2.020	*			
3.284	+/-0.010	3.284	*			
2.200	+/-0.010	2.200	*			
2.750	+/-0.010	2.750	*			
9.521	+/-0.010	9.521	*			
10.22	+/-0.030	10.22	*			
1.373	+/-0.010	1.373	*			
1.62	+/-0.030	1.62	*			
3.564	+/-0.010	3.564	*			
4.236	+/-0.010	4.236	*			
5.636	+/-0.010	5.636	*			
7.049	+/-0.010	7.049	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 8-6-20	Date: 08/09/20	Date:	N/A

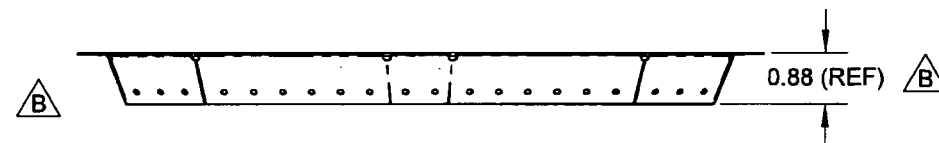
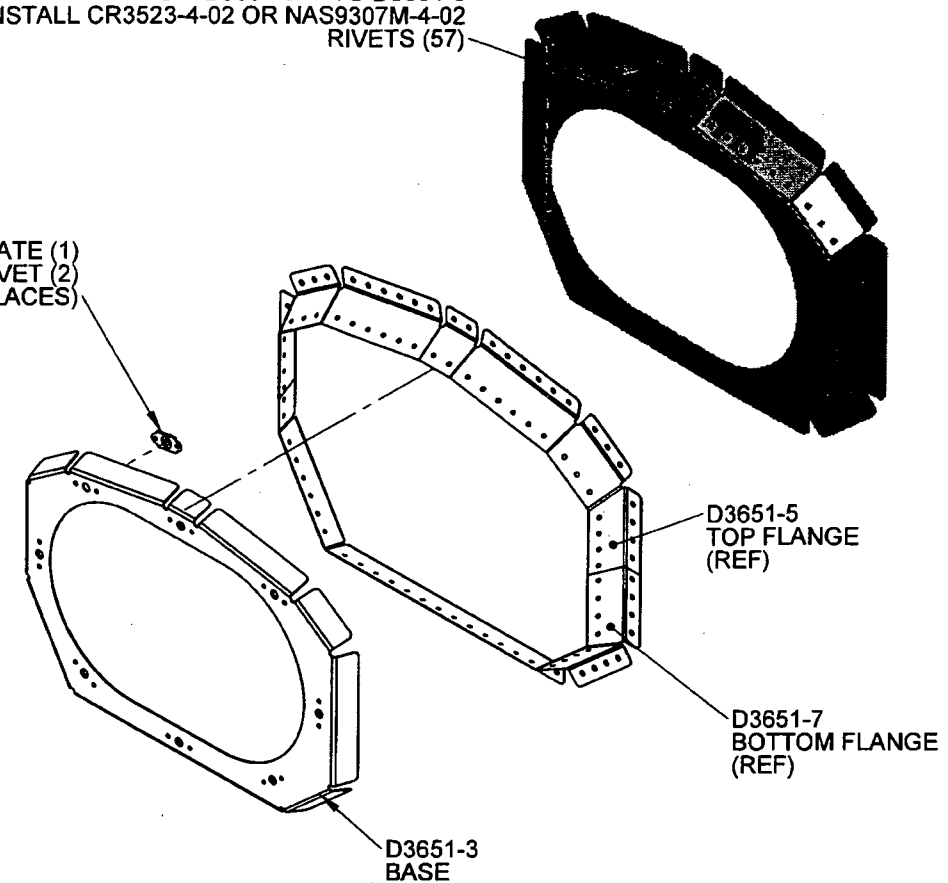
Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	DD

8 7 6 5 4 3 2 1

TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL)
FROM D3651-5/-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)



D3651-043 FLANGE WELDMENT

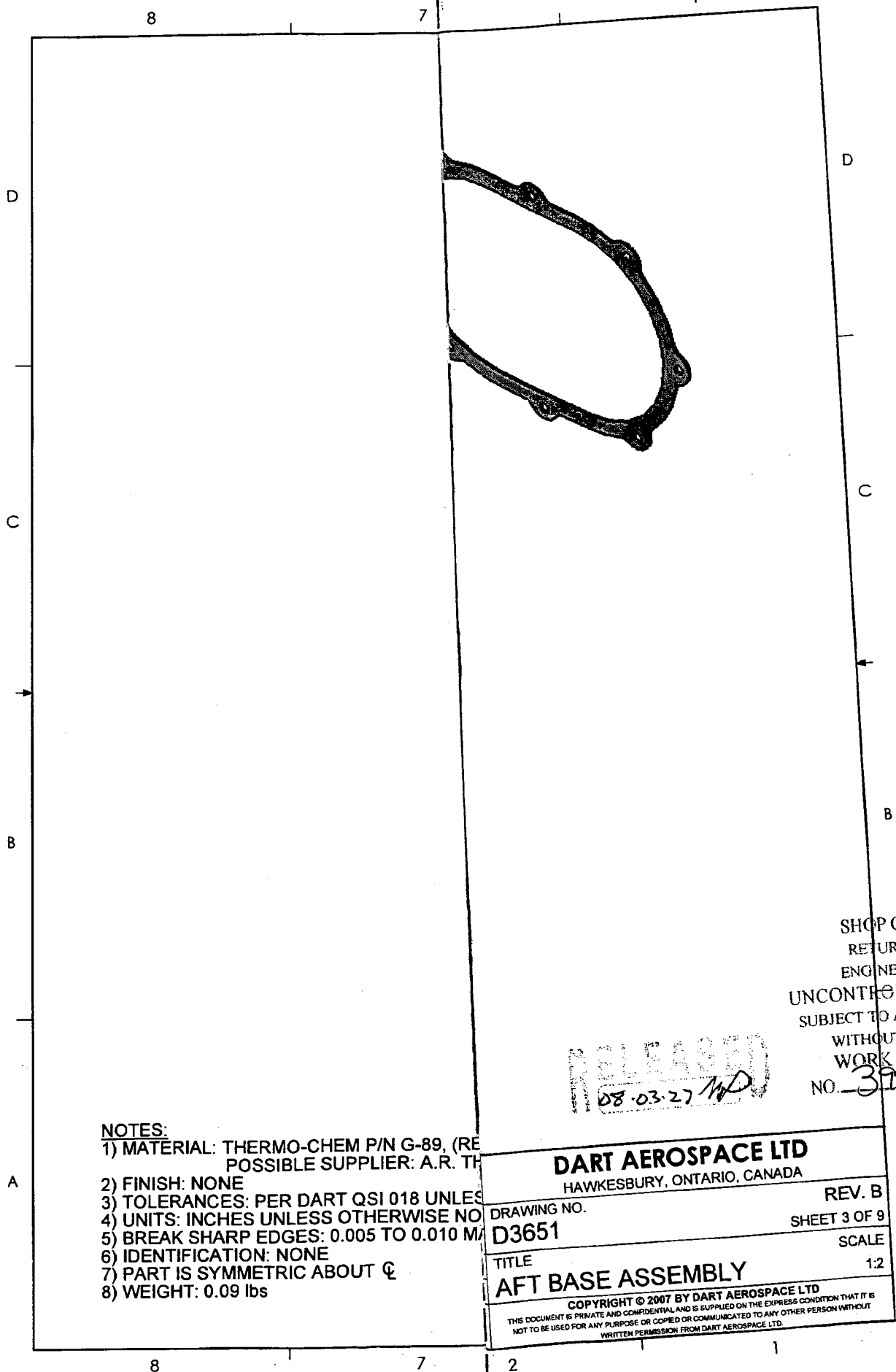
QTY -043	PART NUMBER	DESCRIPTION
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NA9307M-4-02	RIVET

D3651-043 NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	ME	DRAWING NO. D3651	REV. B
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NO. 399/88



NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (RE
POSSIBLE SUPPLIER: A.R. TH
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLES
- 4) UNITS: INCHES UNLESS OTHERWISE NO
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MA
- 6) IDENTIFICATION: NONE
- 7) PART IS SYMMETRIC ABOUT ϕ
- 8) WEIGHT: 0.09 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3651

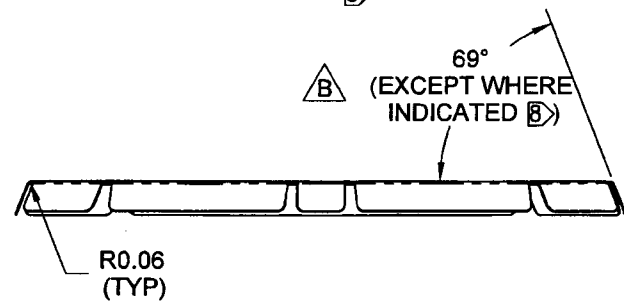
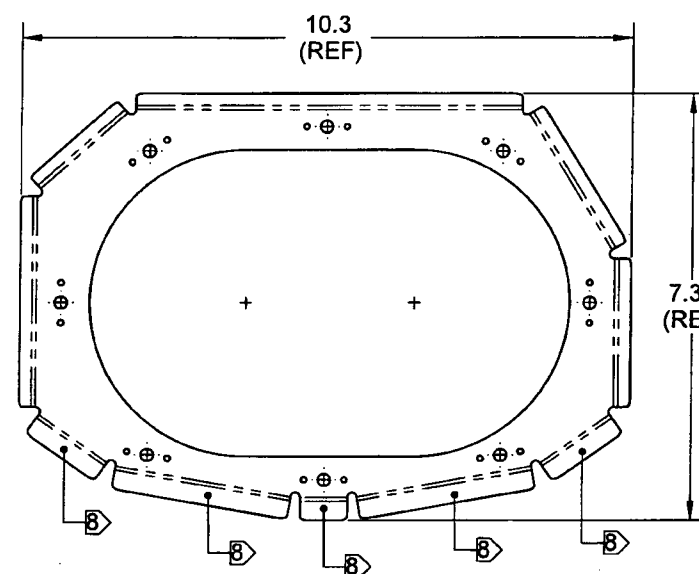
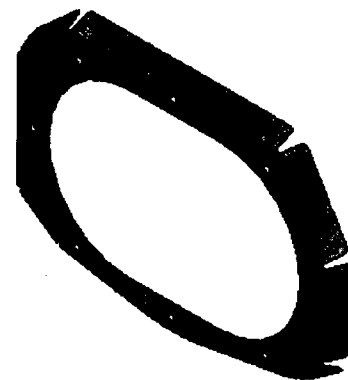
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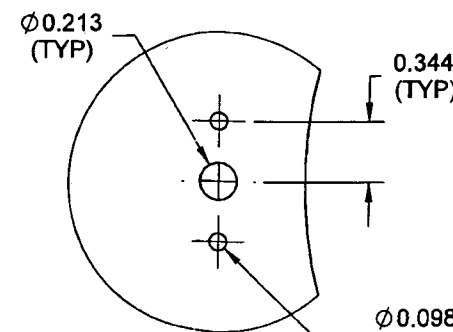
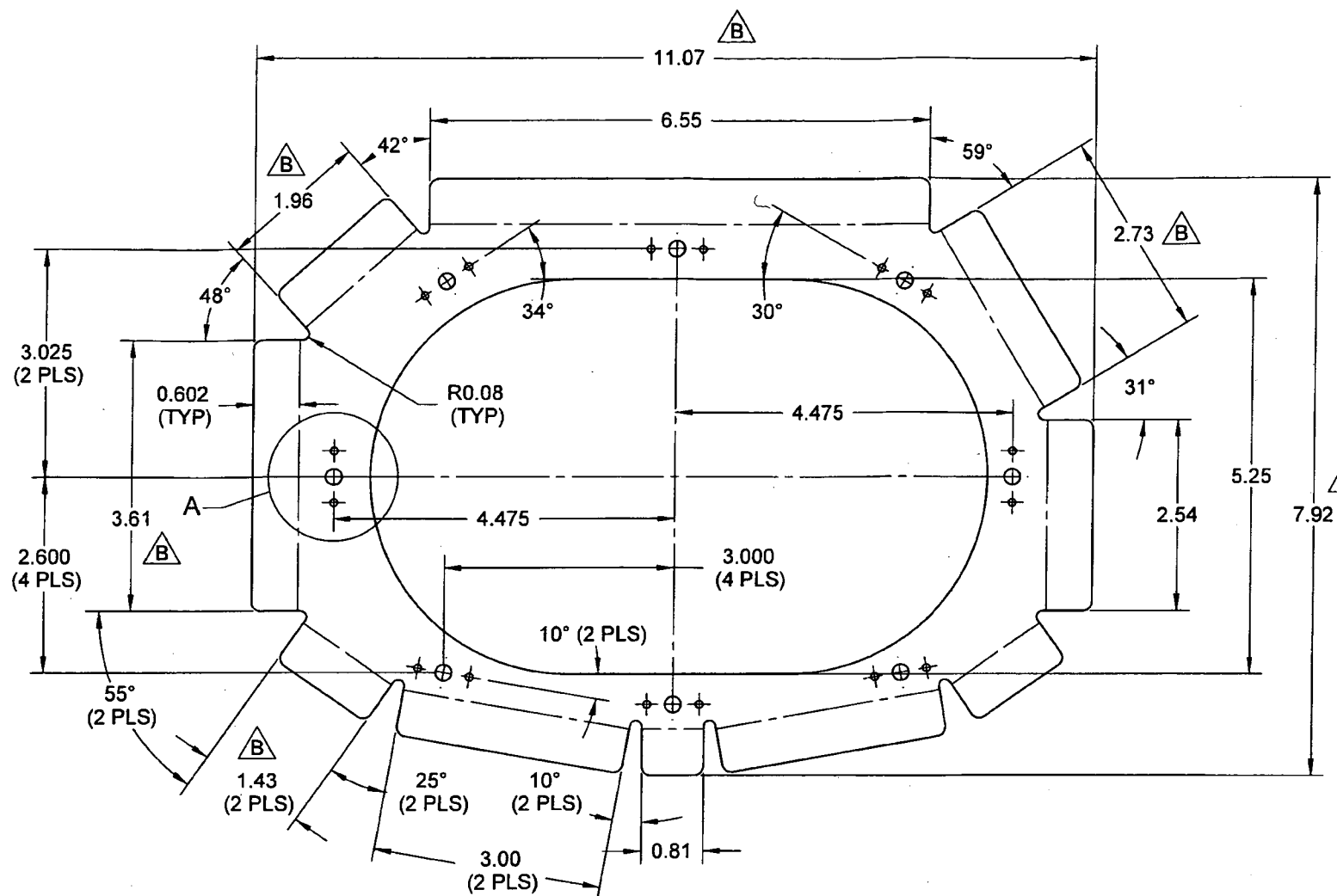
RELEASED
08-03-27 14D



D3651-3 BASE
(MAKE FROM D3651-3F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs
- 8) BEND TO 55° WHERE INDICATED

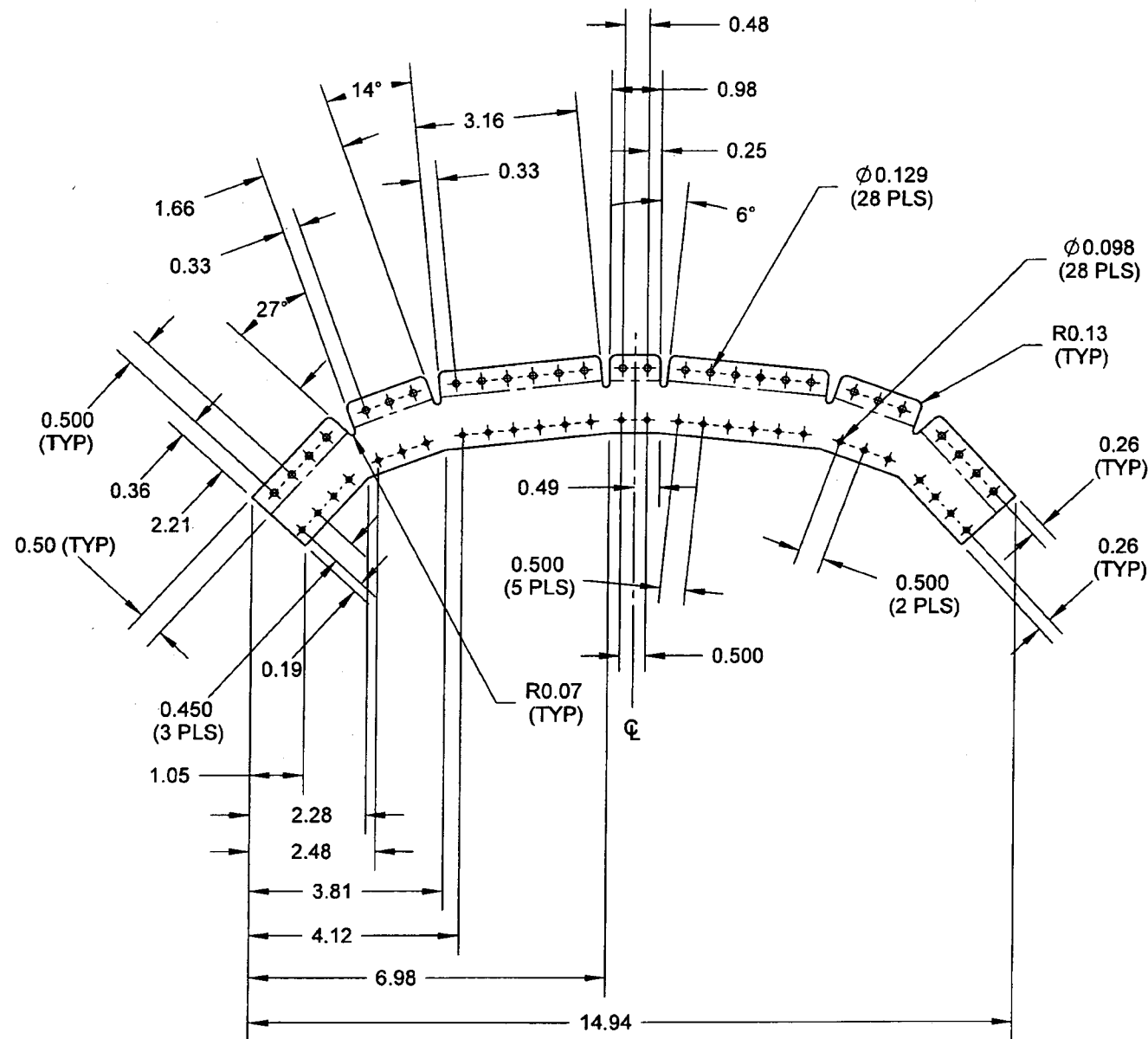


DETAIL A

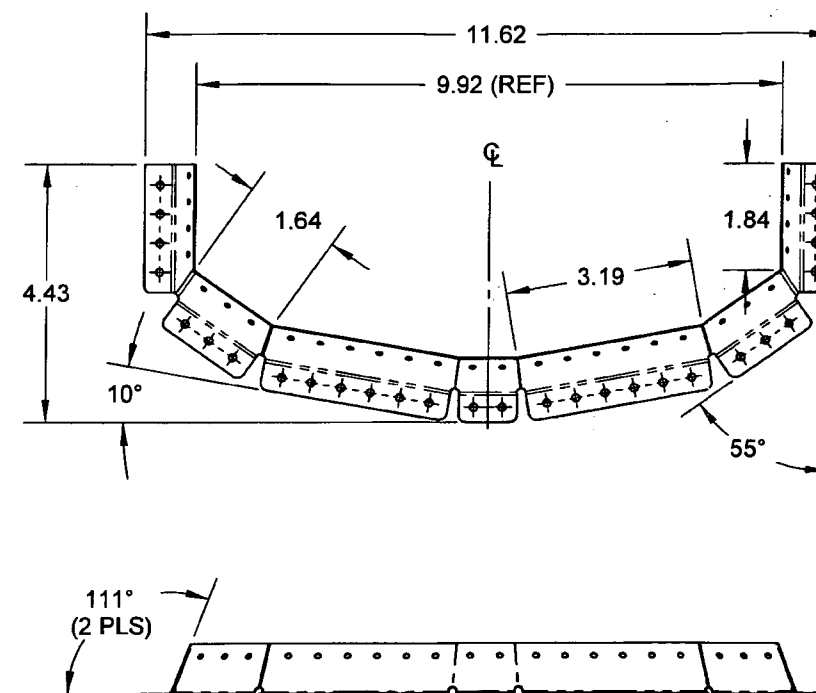
D3651-3F FLAT PATTERN

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
D3651-5F FLAT PATTERN



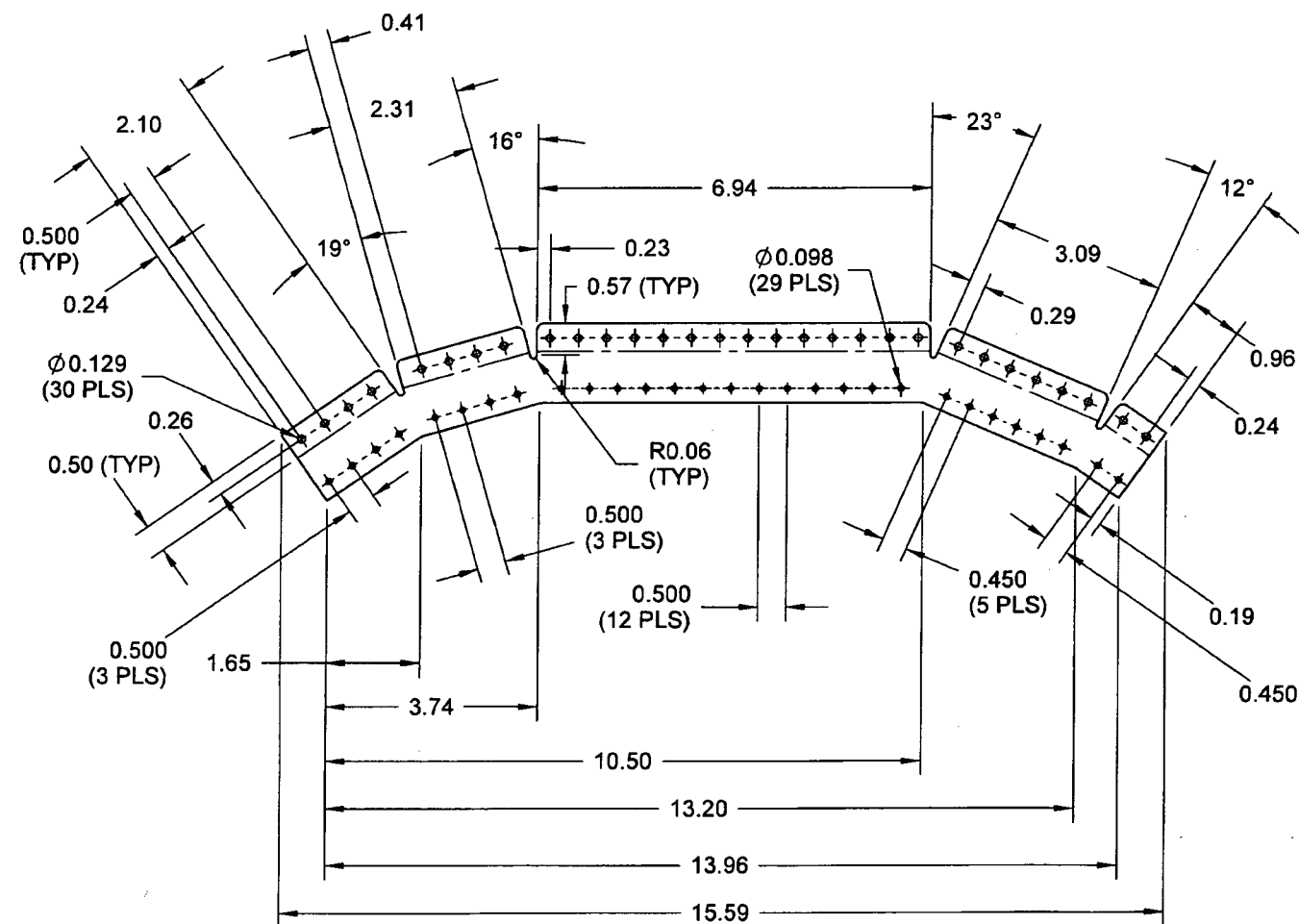
D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
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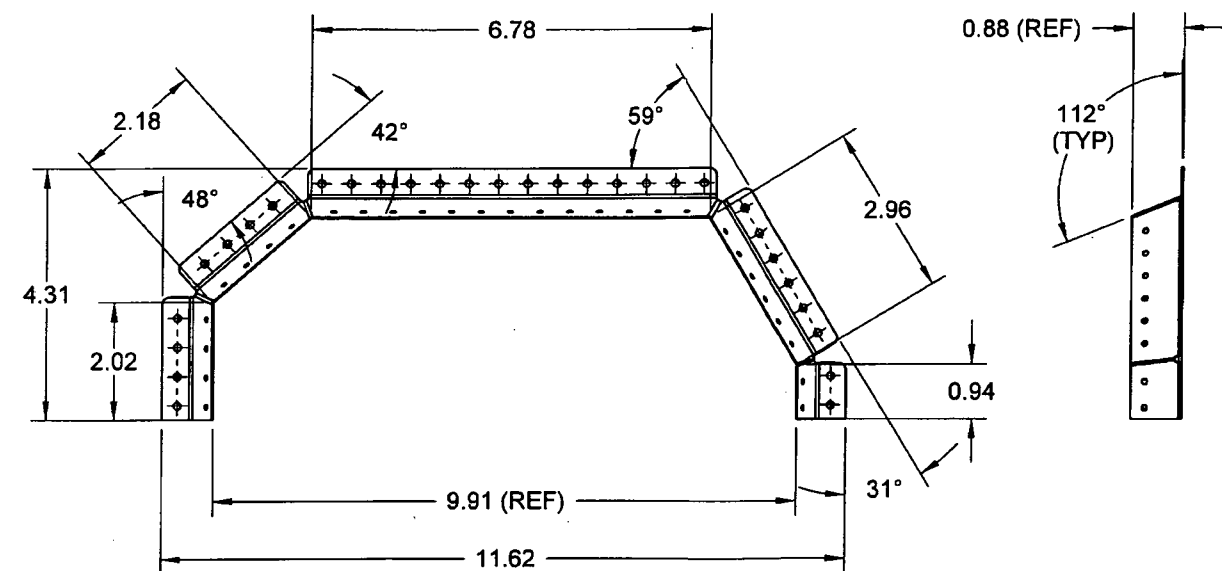
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D3651-7F FLAT PATTERN B

NOTES:

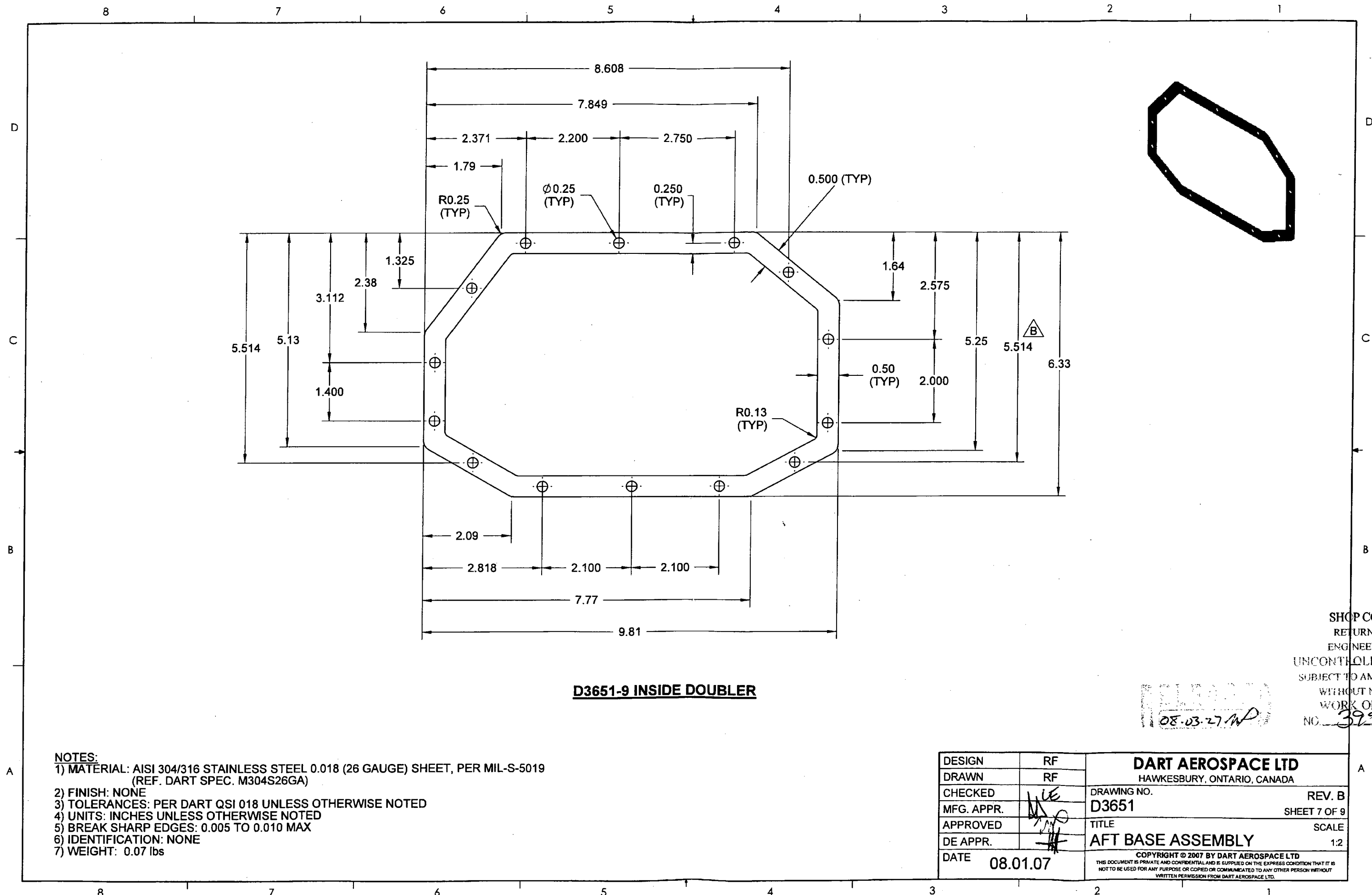
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs



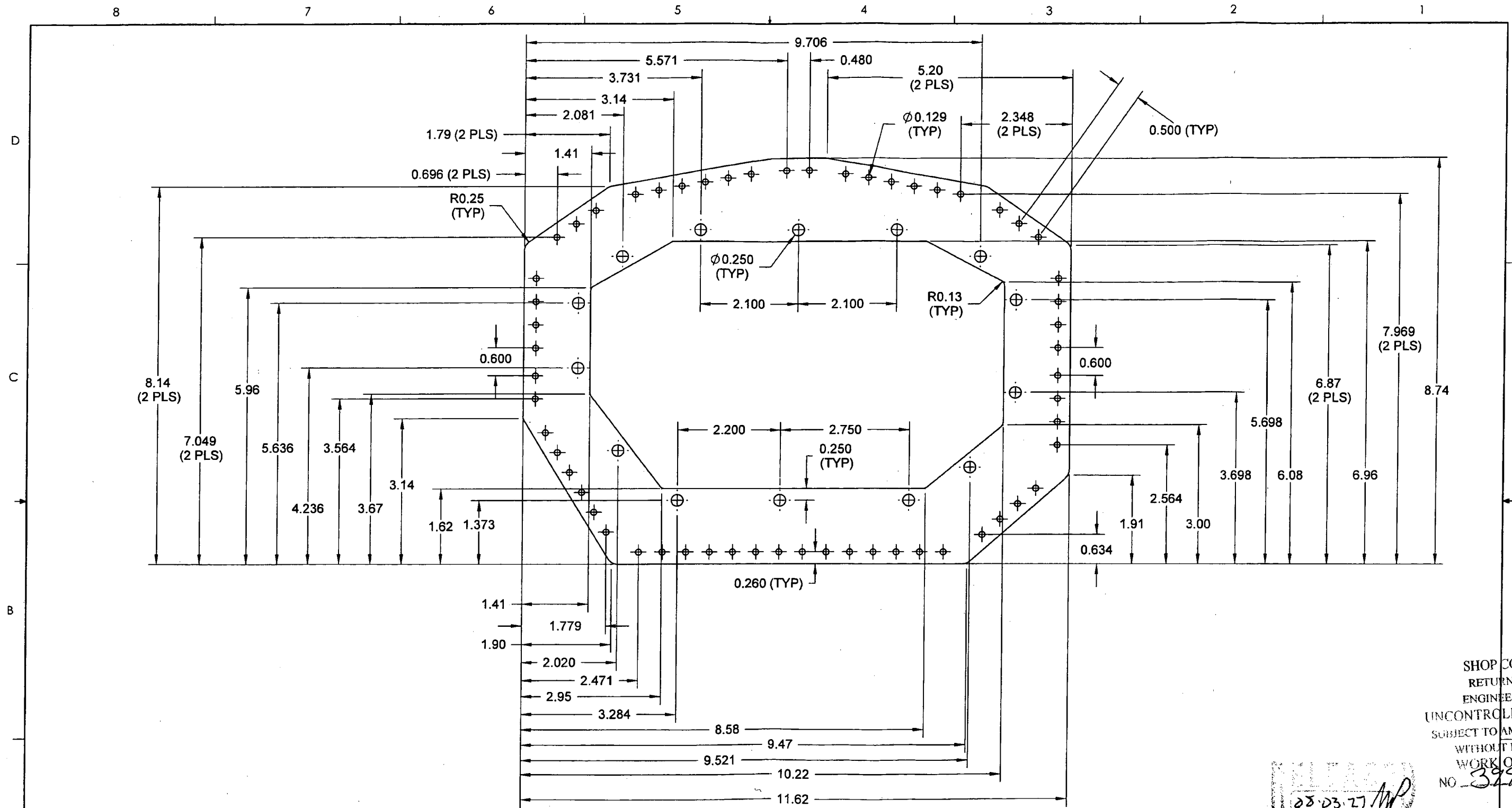
D3651-7 BOTTOM FLANGE BEND DETAIL B
(MAKE FROM D3651-7F FLAT PATTERN)

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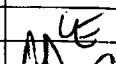

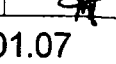


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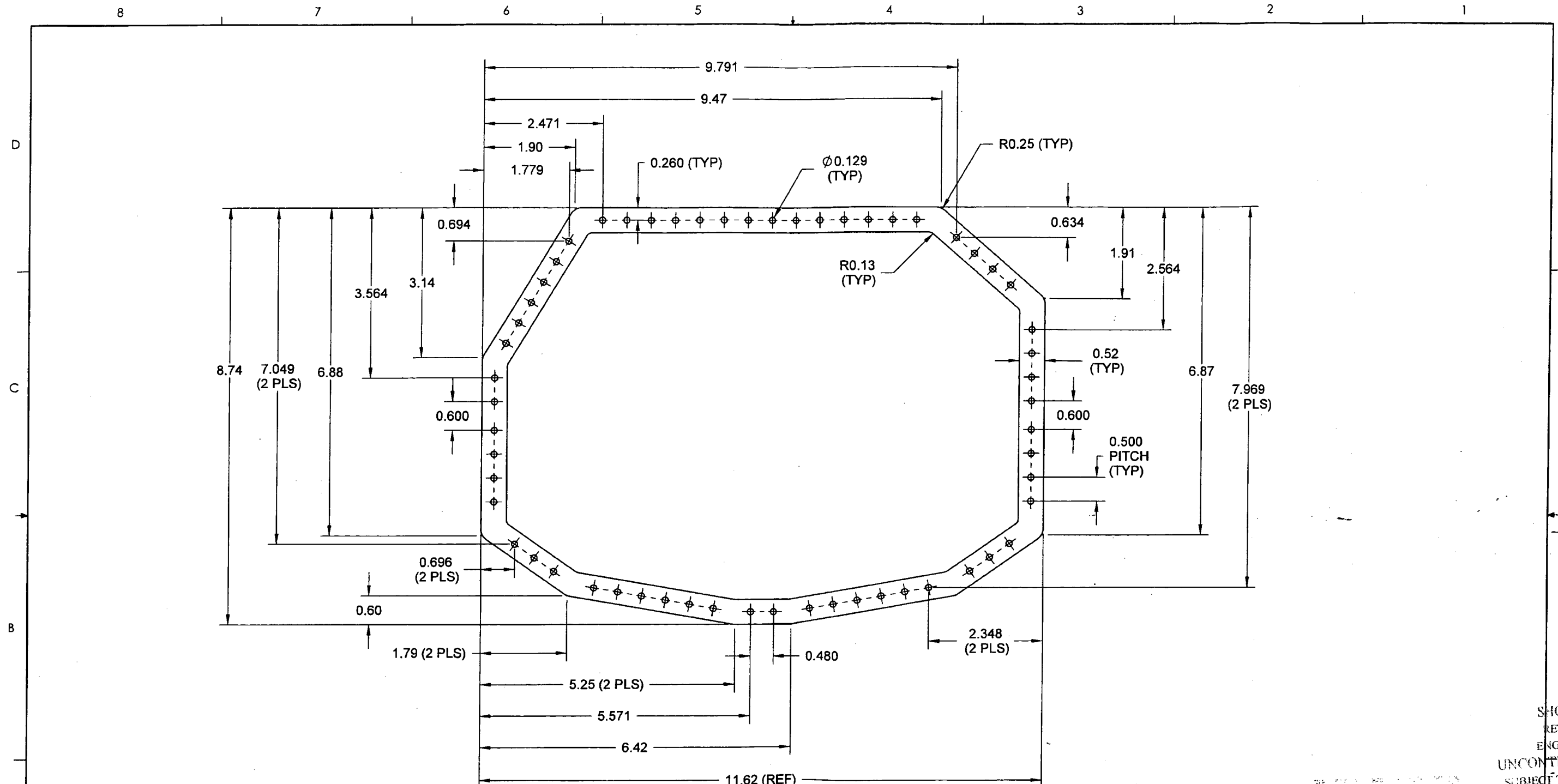


- NOTES:
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.2 lb

D3651-11 GASKET 

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. D3651	REV. B
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D3651-13 OUTSIDE DOUBLER B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>KE</i>	D3651	SHEET 9 OF 9
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